

**Work Order ID 69204**

Wednesday, May 04, 2011 1:15:15 PM



Page 1

Item ID: D212-664-107TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning Detail

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11/05/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D212-664-147

Rev B

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA705

2-Turn first side as per Folio FA113

3-Blend transition lines only, \*\*do not sand whole tube\*\*;

\*Use mill bastard file, brush file repeatedly with file card.

\*Do not use sandpaper coarser than 320 grit.

11/06/20

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

11/06/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	MORI SEIKI CNC LATHE LARGE								
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA705								
	2-Blend transition lines only, **do not sand whole tube** *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit.								
	3- Remove plugs and sand								
130		0.00							
	QC1- Inspect dimensions to dimension sheet								
QC	Memo	0.00							
Quality Control									
140		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

M.M.L 11/06/20

C.M.L 11/06/21

J.L 11/06/21

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Crosstubes Chemical Conversion

0.00

*SAD*  
*JW*

*11-06-22*



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*1* *0* *BE11/06/22*

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack  
Location: *LANDING*

*6000*

*1* *SAD* *11-06-22*

W/O:		WORK ORDER CHANGES					
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Page 4

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Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/23

mk  
11-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, May 04, 2011 1:15:22 PM

Page 1

Work Order ID: 69204



Parent Item: D212-664-107TRN



Parent Item Name: Crosstube Turning Detail

Start Date: 5/4/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD Verified by:ec  
IPP Rev B Removed polish 08.04.02 EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6019-128 		Manufactured	No			110	Each	11.0000	1	1			

Crosstube Material

Location

Loc Qty

Loc Code

LG

11

29369

1

32310

2

50893

8

mm.l 11/06/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> <i>69204</i>
<b>Description:</b> Crosstube Assembly (205/212/412 Low Fwd)	<b>Part Number:</b> D212-664-147
<b>Inspection Dwg:</b> D212-664-147 Rev: B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.313	+/-0.010	0.313	✓	vern	SF-01
	2.360	+0.005/-0.000	2.365	✓	mic	CNC-BU
	2.360	+0.005/-0.000	2.364	✓	✓	
	2.366	+0.005/-0.000	2.369	✓	✓	
	2.473	+0.005/-0.000	2.478	✓	✓	
	2.573	+0.005/-0.000	2.576	✓	✓	
	2.673	+0.005/-0.000	2.678	✓	✓	
	2.750	+0.005/-0.000	2.750	✓	✓	
	2.750	+0.005/-0.000	2.750	✓	✓	
SIDE B	0.313	+/-0.010	0.313	✓	vern	SF-01
	2.360	+0.005/-0.000	2.365	✓	mic	CNC-BU
	2.360	+0.005/-0.000	2.365	✓	✓	
	2.366	+0.005/-0.000	2.369	✓	✓	
	2.473	+0.005/-0.000	2.478	✓	✓	
	2.573	+0.005/-0.000	2.576	✓	✓	
	2.673	+0.005/-0.000	2.678	✓	✓	
	2.750	+0.005/-0.000	2.750	✓	✓	
	2.750	+0.005/-0.000	2.750	✓	✓	
	0.126.528	+/-0.020	126.528	✓	tape	mm. ✓ 02

<b>Measured by:</b> <i>mm. ✓ 02</i>	<b>Audited by:</b> <i>SL</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>11/06/20</i>	<b>Date:</b> <i>11/06/20</i>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.07	New Issue (P/O D212-664-107)	KJ/EC	
B	10.02.02	Dimension 126.528 was 126.53	KJ	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

B				
Item	Qty -147	Qty -147B	Part Number	Description
1	X		D212-664-147	CROSSTUBE ASSEMBLY (205/212/412 LOW FWD)
2		X	D212-664-147B	CROSSTUBE ASSEMBLY (214 LOW FWD)
3	1	1	D6019-128	CROSSTUBE
4	2	2	D2893-1	SUPPORT
5	4	4	D3595-063-450	RUBBER CUSHION
6	2	2	D3659-1	CUFF
7	4	4	MS21920-25	CLAMP (OR MS21920-26)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-2411-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6019-128  
FINISHED LENGTH = 126.528±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-147 = 24.2 lbs (PER IIN-D212-664)  
D212-664-147B = 24.2 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD  
BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%  
BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF  
D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER  
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.  
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE  
UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS  
NOT BOTTOMED-OUT AFTER TORQUING.
- 16) INSTALL D3659-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF  
SIKAFLEX-2411-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.  
SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69204  
PL11 05-4

**RELEASED**  
2009-10-29

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS: ADD -147B (ZN C4-2, D4-2)	RF	09.09.30
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D212-664-147	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE (205/212/412 LOW FWD)	NTS
DATE	09.09.30	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

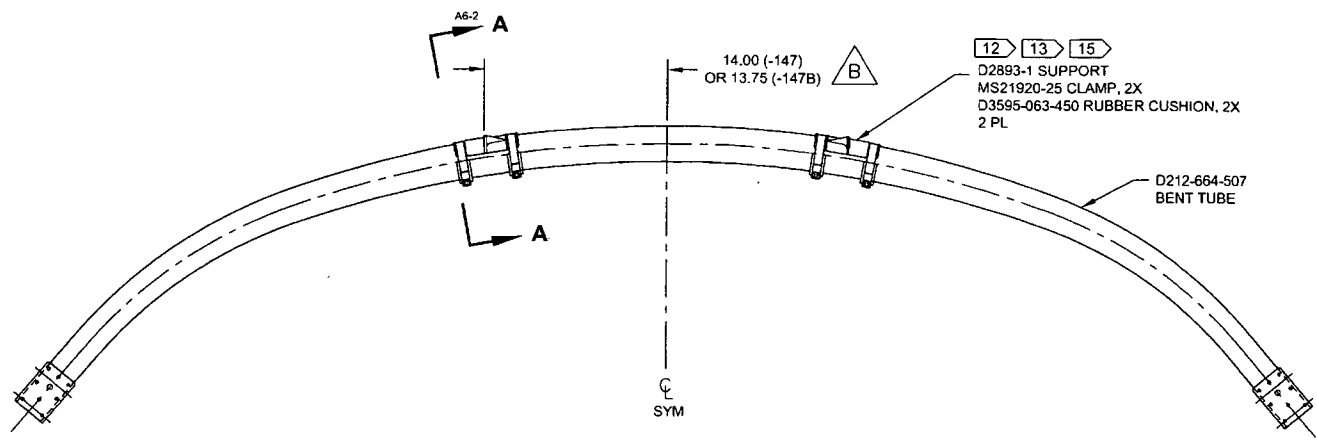
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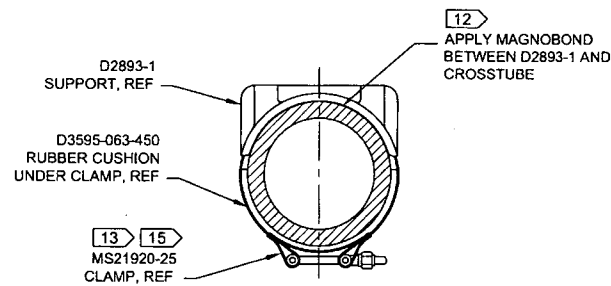
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**D212-664-147/-147B**  
**ASSEMBLY DETAIL**



**SECTION A-A** D5-2  
SCALE 4X

*W/O 69204*

**RELEASED**  
2009-10-29

DESIGN	9P	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9P	DRAWING NO.	REV. B
MFG. APPR.	18	D212-664-147	SHEET 2 OF 4
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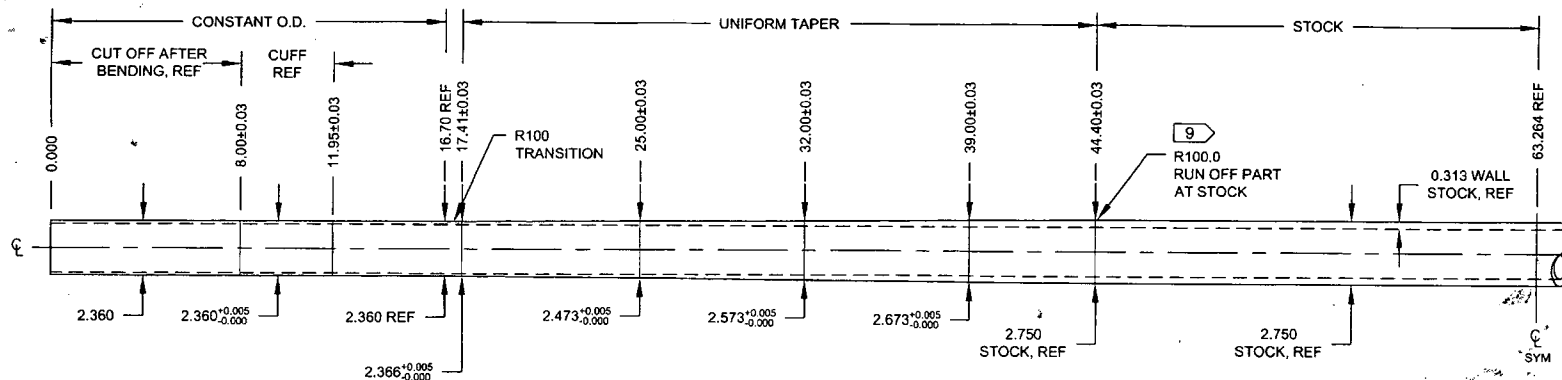
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**D212-664-147TRN**  
**TURNING DETAIL**

*u/o 69204*

**RELEASED**  
2009-10-29

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. B
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